NOTE:
ALL DIM'S ABOVE BEND LINE ARE ACTUAL DIM'S. IN PLANE OF PLATE -6L, R.

NOTE: JIG DRILL ALL HOLES 1/4 EXCEPT 15-5/16 HOLES NOTED ABOVE & 1-3/16 HOLE NOTED BELOW

JIG DRILL 15-5/16 HOLES

BEND LINE

JIG BORE & REAM 1.5750

(13) L,R AS MACHINED AFTER WELDING AND H.T.

(20) L,R WELDED ASSY

BUSHING 28L5037-7 PRESS IN WITH WET PRIMER REAM 1.125 IF NECESSARY AFTER INSERTING BUSHINGS

JIG CENTER BORE & REAM 1.5750

NOTE: JIG DRILL 3/16 (1 HOLE)

ALL RADII ON -6 L,R EXCEPT AS SHOWN

MACHINE WELD IF NECESSARY TO 3/16 R IN THIS REGION ONLY

EDGE DISTANCE NOMINAL 5/16 MINIMUM 9/32

WELD RAD 1/8 MAX.

13.252 ±.010 CENTER TO CENTER TRUE DIM.

28B5512-7L & -7R

JIG DRILL 1/4 (8 PLACES SPACE EQUALLY AS SHOWN

MACHINE WELD IF NECESSARY TO 3/16 R IN THIS REGION ONLY

L H PART SHOWN

CHAMFER 45°

SECTION E-E

FINISH:
-20 L,R-SB
-13 L,R-C-P-2AP

HEAT TREAT:
-20 L,R - 175,000 PSI

NOTE:
IF BUSHINGS 28L5037-7 COVERS LUBRICATOR HOLE, RUN THRU WITH DRILL AFTER INSTALL

FINISH CODE
C CADMIUM PLATE
SB SAND BLAST

JIG DRILL 5/16 (7 REQ'D)

JIG DRILL 5/16 (7 REQ'D)

JIG DRILL 1/4 (10 REQ'D)

JIG DRILL 5/16 (10 REQ'D)

WELD RAD. 1/8 MAX.

WELD RAD. 1/8 MAX.

WELD RAD. 1/8 MAX.

SECTION A-A

SECTION B-B

SECTION C-C

SECTION D-D

NOTE:
WELD ONLY ON SIDES DESIGNATED

AN 206-2

28L5037-7

-13R MAKE FROM -20R
-13L MAKE FROM -20L

REQUIREMENTS PER AIRPLANE

SCALE 6"=1'0"

PART No. | STOCK | MATERIAL | SPEC

PARTS LIST PER ASSY

HEAT TREAT: NOTED
FINISH: NOTED

NAME FITTING - HULL LANDING GEAR - STA 4.2

CONSOLIDATED AIRCRAFT CORP. SAN DIEGO, CALIF.

OPP HAND 28B5502-R

J 28B5502

H 136